

Work Order ID 78748

78748

Page 1

January-13-12 10:44:14 AM

Item ID: D3135-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Handle Weldment

Start Date: 13/01/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 27/01/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: M.L.JDate: 12/01/13 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3135	Rev D					(2)			
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3135 Dwg Rev: <u>D</u> Prog Rev: <u>2</u> -								
304, 063	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

B12-8-7

B12-8-1

SMB

12-8-07

DAS
16
2-8

12/06/07

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3135-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Handle Weldment
 Start Date: 13/01/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 27/01/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					2	0		FF 12-08-08
Small Fab	Memo	0.00							
Small Fab	1-Bend D3135-1 as per template D3135-1T2 and Dwg D31352-Deburr ends								
140		0.00							
140	QC5- Inspect part completeness to step on W/O					2			
QC	Memo	0.00	Smb						
Quality Control		12-8-08							
150		0.00							
150	Large Fab					2			12-8-9
Large Fab	Memo	0.00							
Large Fab	1-Weld handle onto plate as per Dwg D3135 and QSI 004 304 S.S. welding rod Batch: <u>M114509</u>								

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 Start Date: 13/01/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 27/01/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				2	12.8.9		DAS 24 8-89
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				2	12.8.9		DAS 24 8-89
180 *180* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 3h50 320°F FINISH TIME: 4h20	0.00 0.00				2	x	(DP) 12/08/09.	

OVEN TEMPERATURE: m. 21 279✓

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 13/01/2012 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 27/01/2012 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

2X

12-8-10

200

Identify as per dwg & Stock Location **236B**

0.00

200

Packaging

Memo

0.00

Packaging

2x

12/8/10

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/8/13

12/08/10

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Picklist Print

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Page 1

Work Order ID: 78748

78748

Parent Item: D3135-041

D3135-041

Parent Item Name: Handle Weldment

Start Date: 13/01/2012

Required Date: 27/01/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: A03.03.06New IssueKJ/RF
IPP Rev:B 08-01-15 now on water jet DD
IPP Rev:C 08-05-22 revD as per dwg ECN1192 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.375W.065

Purchased

No

100

f

52.2500

0.4167

0.877263

M304TR0 375W 065

304 RD Tube .375 x .065W

**

② FF 12-08-08

Location

Loc Qty

Loc Code

MAT016

52.25

111097

1.75

120183

50.5

0.87726

M304S16GA

Purchased

No

130

sf

97.3300

0.3

0.631579

M304S16GA

304/316 Sheet .063

**

B12-8-7

Location

Loc Qty

Loc Code

MAT020

97.33

119346

29.5

119653

67.83

122245

122245

②

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

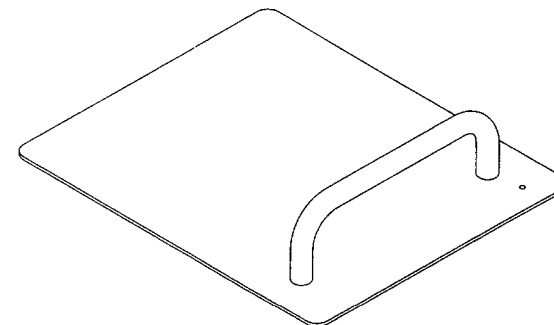
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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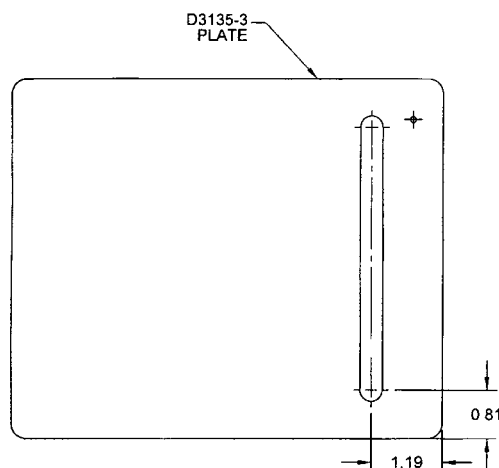
NOTE: Date & initial all entries

QTY. 041	PART NUMBER	DESCRIPTION
X	D3135-041	HANDLE WELDMENT
1	D3135-1	HANDLE
1	D3135-3	PLATE

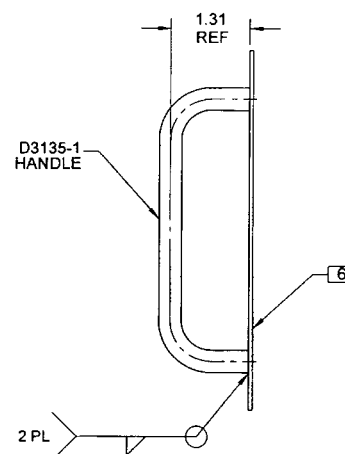
SHOP COPY
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ENCL
UNCONT
SUBJECT
WITH
NO - 78748 M.C.J
12/01/13



D3135-041 HANDLE WELDMENT



D3135-041 HANDLE WELDMENT



RELEASED

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT COLOUR GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES. N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3135-041" AND BATCH "BXXXXX" USING FINE POINT PERMANENT INK MARKER OR FIX LABEL AFTER FINISHING
- 7) WEIGHT: 0.90 lbs
- 8) WELD PER DART QSI 004

D	REDRAWN TO SOLIDWORKS FORMAT. ZN D4-2 TOOLING HOLE ADDED REASON: PRODUCTION REQUEST FOR TOOLING HOLE	AJS	08.05.07
C	REMOVED Ø0.221 HOLES	DS	04.10.06
B	6.400 WAS 6.330; ADD "ANNEALED"	DS	03.03.04
A	NEW ISSUE	DS	02.04.17
REV	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO	REV. D
MFG. APPR.		D3135	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HANDLE WELDMENT	NTS
DATE	08.05.07	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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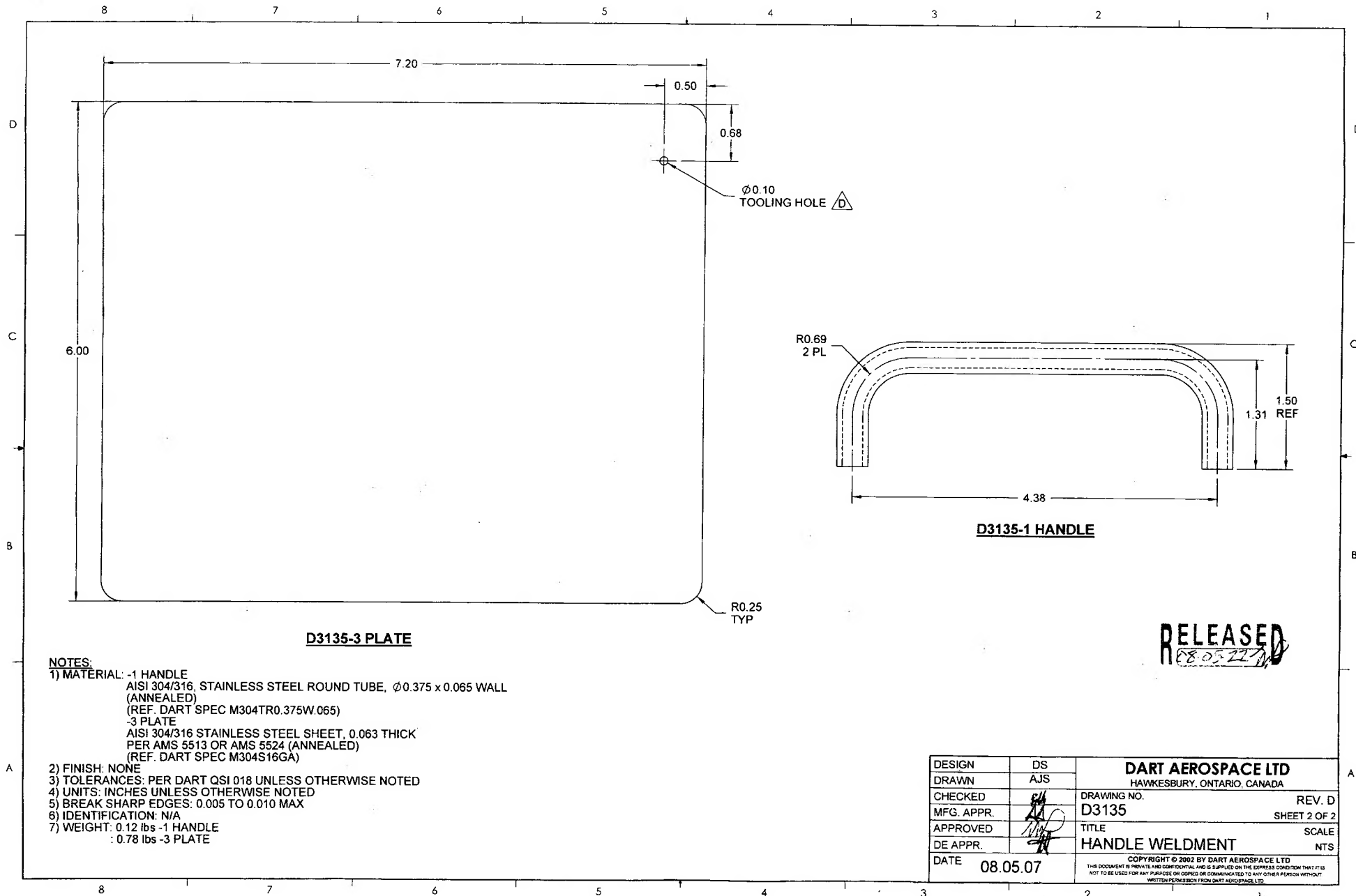
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